

ABSTRACT OF THE DISCLOSURE

A multi-layer web formation section has at least two successive wire units (300, 310). First and second headboxes (100, 110) supply pulp suspension jets to the forward end of the first wire unit (300) and the second wire unit respectively to form
5 a first partial web (W1) and a second partial web (W2) which are joined at a joint (N1) between the second wire unit (310) and a bottom wire (11). A first non-pulsating dewatering zone (Z1b) in the forward end of a two-wire stretch of the second wire unit (310) is formed by a fixed formation shoe (200b) having a curved cap (201) placed against one side, having openings with an under-pressure applied.
10 A two-wire stretch of the second wire unit (310) has a second pulsating dewatering zone (Z2b), formed by fixed dewatering lists (210b) in the cross machine direction with gaps (220b) therebetween with an under-pressure (Pb) applied.